

ITEM NO.	QTY. -101	PART NUMBER	DESCRIPTION
1	X	E4627-101	SOLID LINE KIT
2	1	E4627-041	DRAIN TUBE ASSEMBLY
3	1	E4627-043	DRAIN TUBE ASSEMBLY
4	1	E4627-045	DRAIN TUBE ASSEMBLY
5	1	E4627-059	OIL TUBE ASSEMBLY
6	1	E4627-061	TUBE ASSEMBLY
7	1	E4627-063	TUBE ASSEMBLY
8	1	E4627-065	BRAKE LINE ASSEMBLY
9	1	E4627-067	CROSSOVER LINE ASSEMBLY
10	1	E4627-069	TX DRAIN LINE ASSEMBLY
11	1	E4627-071	LINE ASSEMBLY
12	1	E4627-073	BLEED AIR LINE ASSEMBLY
13	1	E4627-075	BLEED AIR SENSE LINE ASSEMBLY
14	1	E4627-077	BLEED AIR LINE ASSEMBLY

E4627-101 SOLID LINE KIT

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

A	NEW ISSUE	<i>AS</i>	12.12.03	
REV.	DESCRIPTION		BY DATE	
DESIGN	<i>AS</i>	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA		
DRAWN	<i>AS</i>			
CHECKED	<i>AS</i>	DRAWING NO.	REV. A	
MFG. APPR.	N/A	E4627	SHEET 1 OF 19	
APPROVED	<i>#</i>	TITLE	SCALE	
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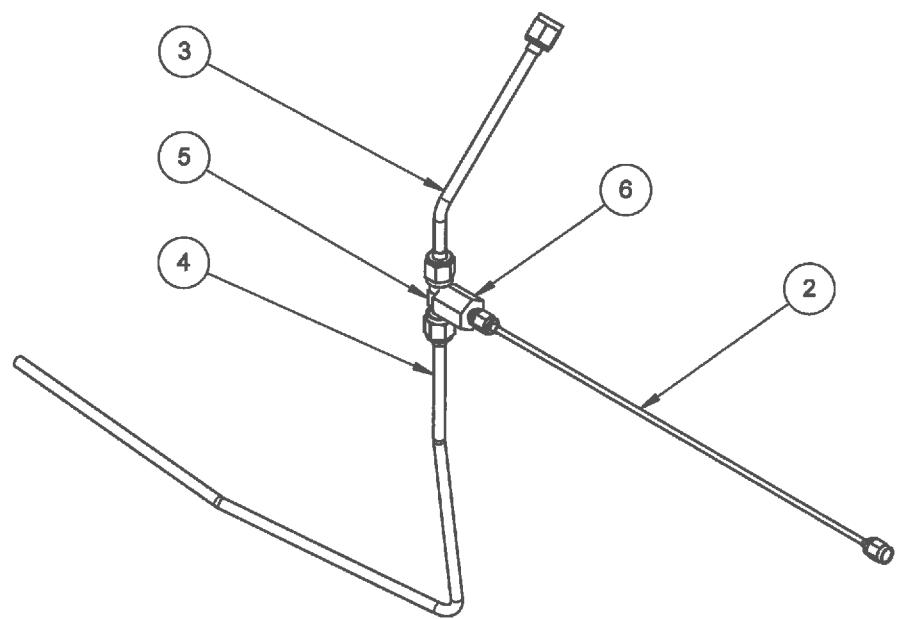
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	E4627-041	DRAIN TUBE ASSEMBLY
2	1	E4627-047	DRAIN TUBE ASSEMBLY
3	1	E4627-049	DRAIN TUBE ASSEMBLY
4	1	E4627-051	DRAIN TUBE ASSEMBLY
5	1	AN824-4D	TEE FITTING
6	1	MS24398D4-2	FITTING



E4627-041 DRAIN TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.08 lbs

DESIGN	<i>AB</i>	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA
DRAWN	<i>AB</i>	
CHECKED	<i>AB</i>	DRAWING NO.
MFG. APPR.	N/A	E4627
APPROVED	<i>AB</i>	REV. A
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ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	E4627-043	DRAIN TUBE ASSEMBLY
2	1	E4627-053	DRAIN TUBE ASSEMBLY
3	1	E4627-055	DRAIN TUBE ASSEMBLY
4	1	AN824-4D	TEE FITTING

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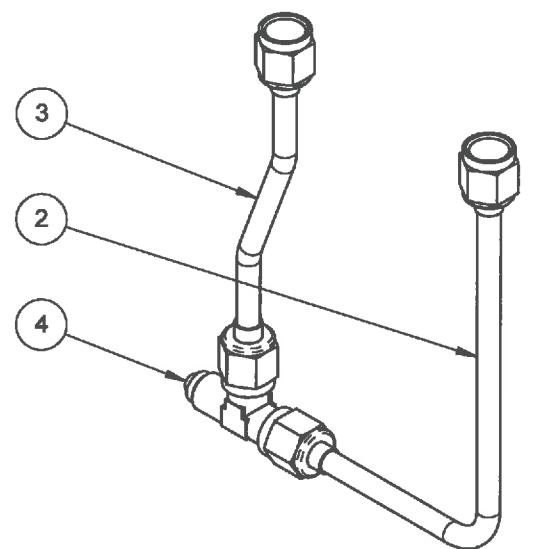
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NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

**E4627-043 DRAIN TUBE ASSEMBLY**

DESIGN	<i>AS</i>	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA
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MFG. APPR.	N/A	E4627
APPROVED	<i>AS</i>	REV. A
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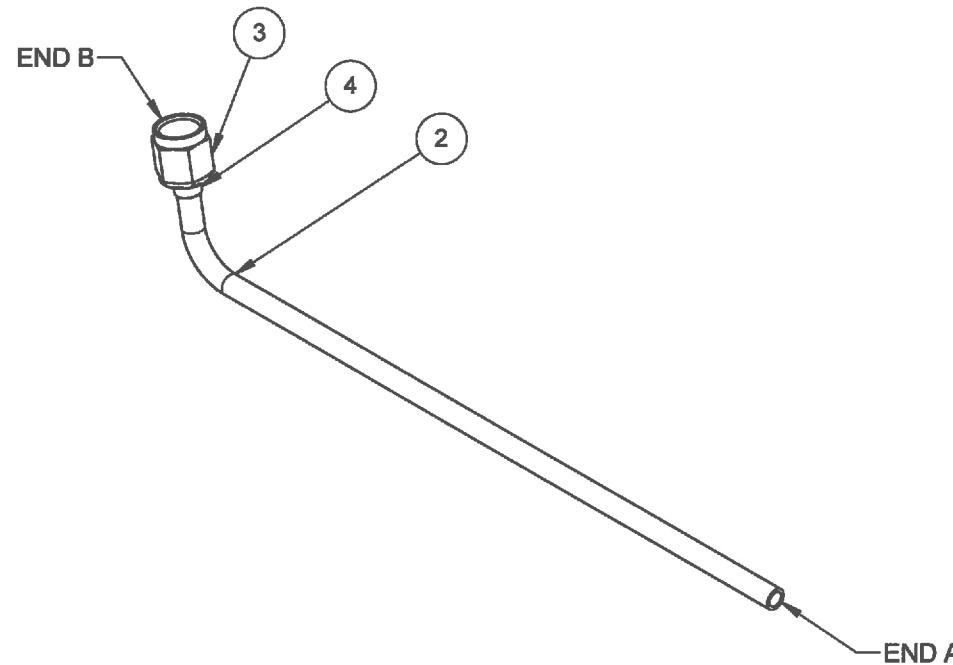
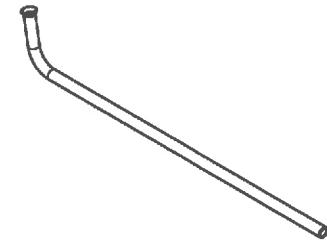
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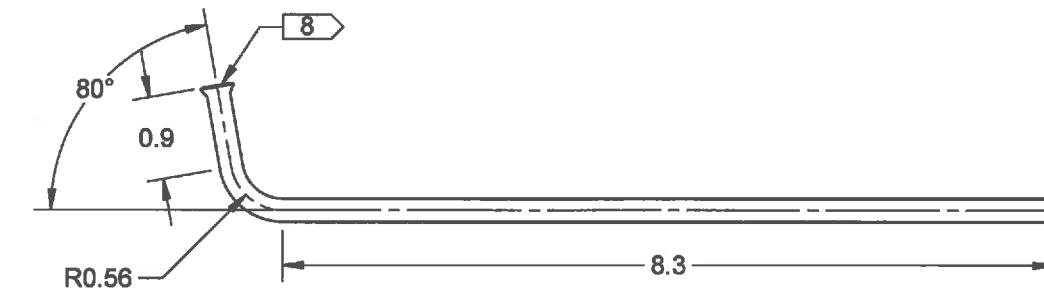
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ITEM NO.	QTY. -045	PART NUMBER	DESCRIPTION
1	X	E4627-045	DRAIN TUBE ASSEMBLY
2	1	E4627-1	TUBE
3	1	AN818-4D	NUT COUPLING
4	1	MS20819-4D	SLEEVE COUPLING

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	0.56	8.64	80.0	0.0
END B	-	10.47	-	-



E4627-045 DRAIN TUBE ASSEMBLY



E4627-1 TUBE

NOTES:

- 1) MATERIAL: 6061-T4 ALUMINUM TUBING, $\phi 0.250 \times 0.035$ WALL PER MIL-T-7081
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs
- 8) FLARE TUBE PER MS33584
- 9) NO PRESSURE TEST REQUIRED
- 10) MARK LINE WITH BRADY B-999 "FUEL" AND "DRAIN" TAPE

DESIGN	<i>[Signature]</i>	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA
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CHECKED	<i>[Signature]</i>	DRAWING NO. E4627
MFG. APPR.	<i>N/A</i>	
APPROVED	<i>[Signature]</i>	REV. A SHEET 4 OF 19
DE APPR.	<i>[Signature]</i>	
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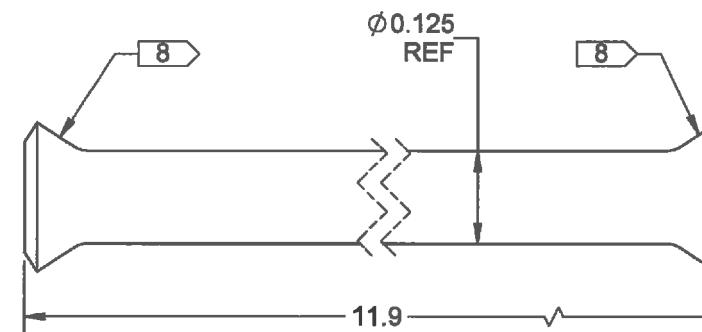
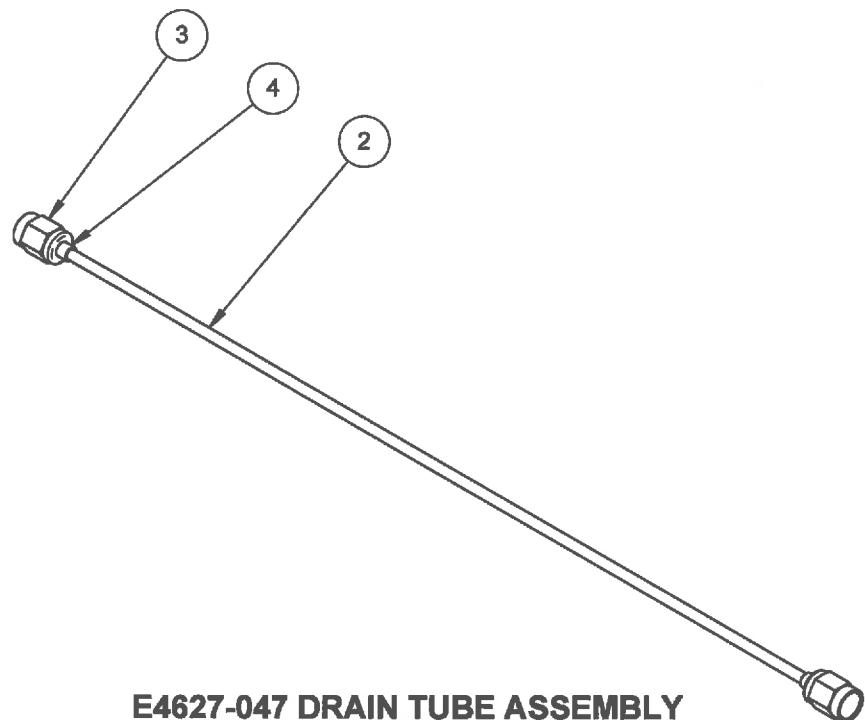
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ITEM NO.	QTY. -047	PART NUMBER	DESCRIPTION
1	X	E4627-047	DRAIN TUBE ASSEMBLY
2	1	E4627-3	TUBE
3	2	AN818-2D	NUT COUPLING
4	2	MS20819-2D	SLEEVE COUPLING

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
END B	-	11.86	-	-



NOTES:

- 1) MATERIAL: 5052-O ALUMINUM TUBING, Ø0.125 X 0.035 WALL PER WW-T-700/4
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs
- 8) FLARE TUBE PER MS33584
- 9) MARK LINE WITH BRADY B-999 "DRAIN" TAPE
- 10) PRESSURE TEST TO 100 PSI

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APPROVED	<i>[Signature]</i>	
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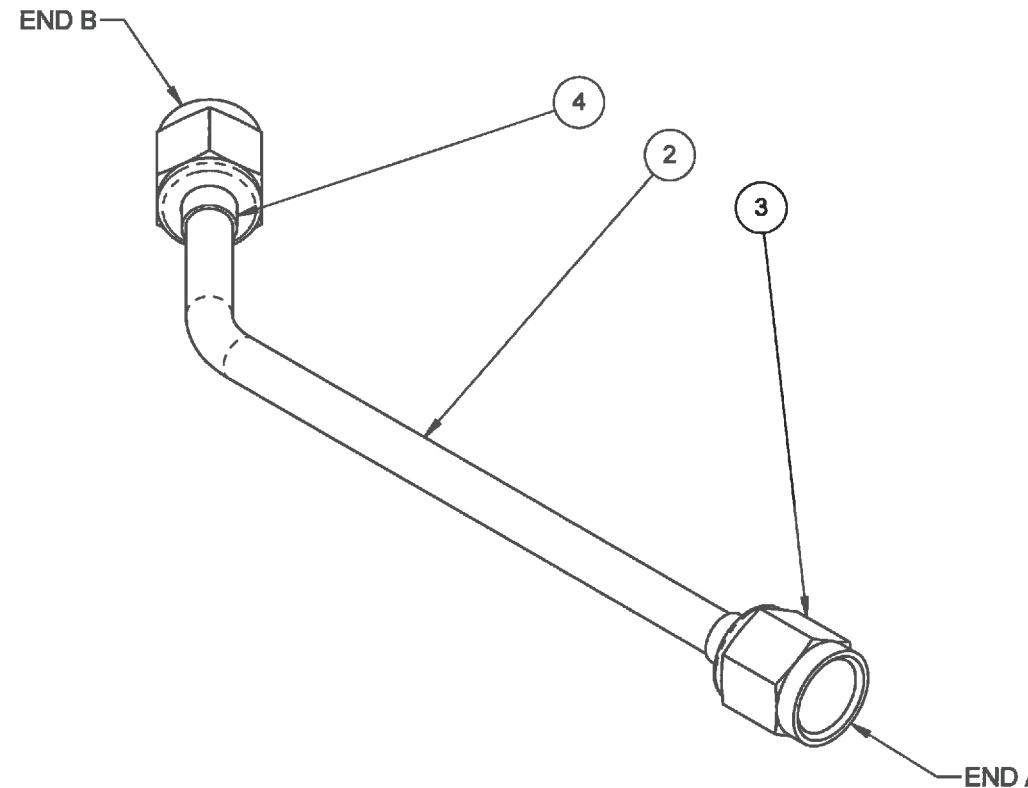
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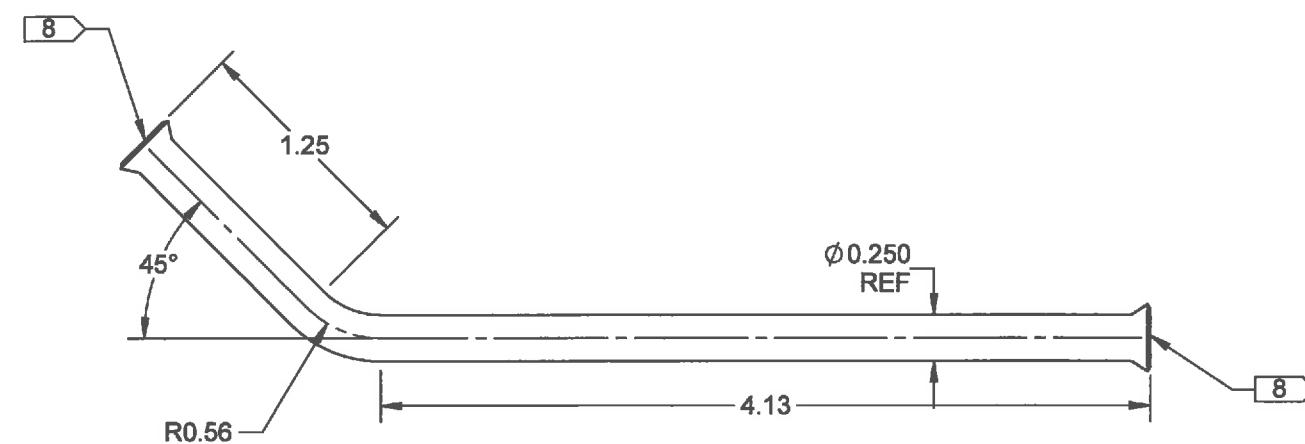
ITEM NO.	QTY. -049	PART NUMBER	DESCRIPTION
1	X	E4627-049	DRAIN TUBE ASSEMBLY
2	1	E4627-5	TUBE
3	2	AN818-4D	NUT COUPLING
4	2	MS20819-4D	SLEEVE COUPLING

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E4627-049 DRAIN TUBE ASSEMBLY

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	0.56	4.14	45.0	0.0
END B	-	5.95	-	-



E4627-5 TUBE

NOTES:

- 1) MATERIAL: 6061-T4 ALUMINUM TUBING, Ø0.250 X 0.035 WALL PER MIL-T-7081
- 2) FINISH: CHEMICAL CONVERSION COAT PER DAT QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs
- 8) FLARE TUBE PER MS33584
- 9) PRESSURE TEST TO 100 PSI
- 10) MARK LINE WITH BRADY B-999 "FUEL" AND "DRAIN" TAPE

DESIGN	<i>[Signature]</i>	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA
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CHECKED	<i>[Signature]</i>	DRAWING NO. REV. A
MFG. APPR.	N/A	E4627 SHEET 6 OF 19
APPROVED	<i>[Signature]</i>	TITLE SCALE
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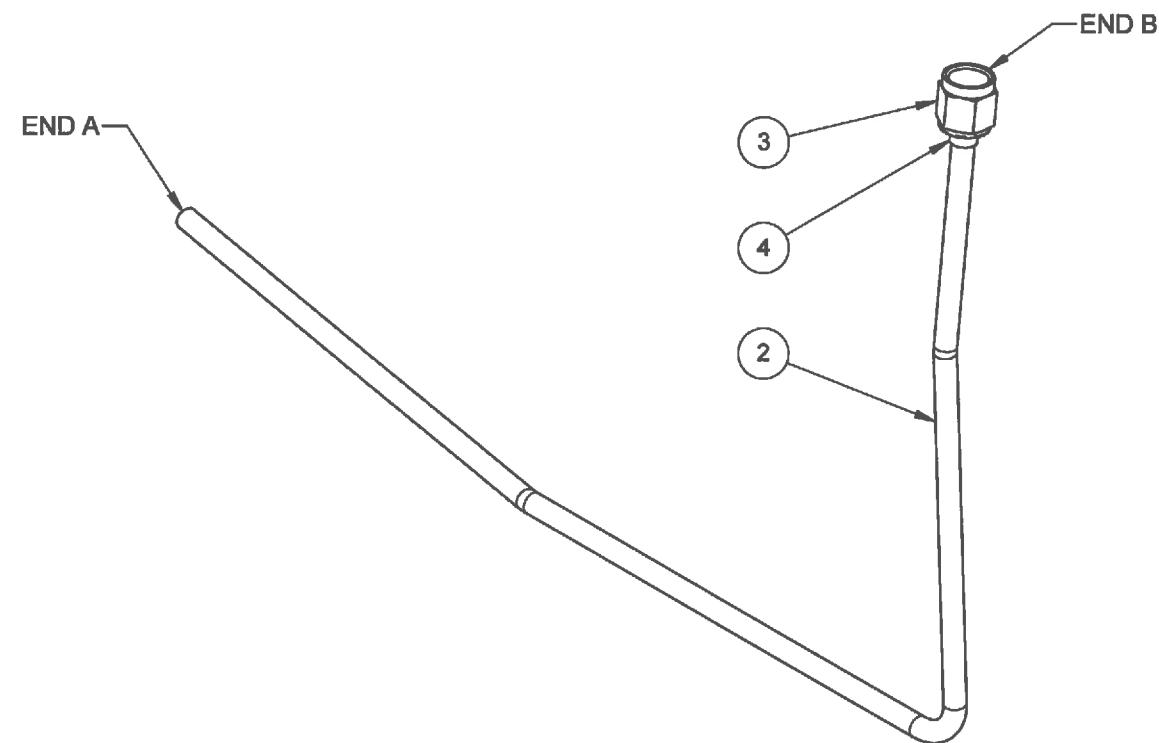
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8 7 6 5 4 3 2 1

ITEM NO.	QTY. -051	PART NUMBER	DESCRIPTION
1	X	E4627-051	DRAIN TUBE ASSEMBLY
2	1	E4627-7	TUBE
3	1	AN818-4D	NUT COUPLING
4	1	MS20819-4D	SLEEVE COUPLING

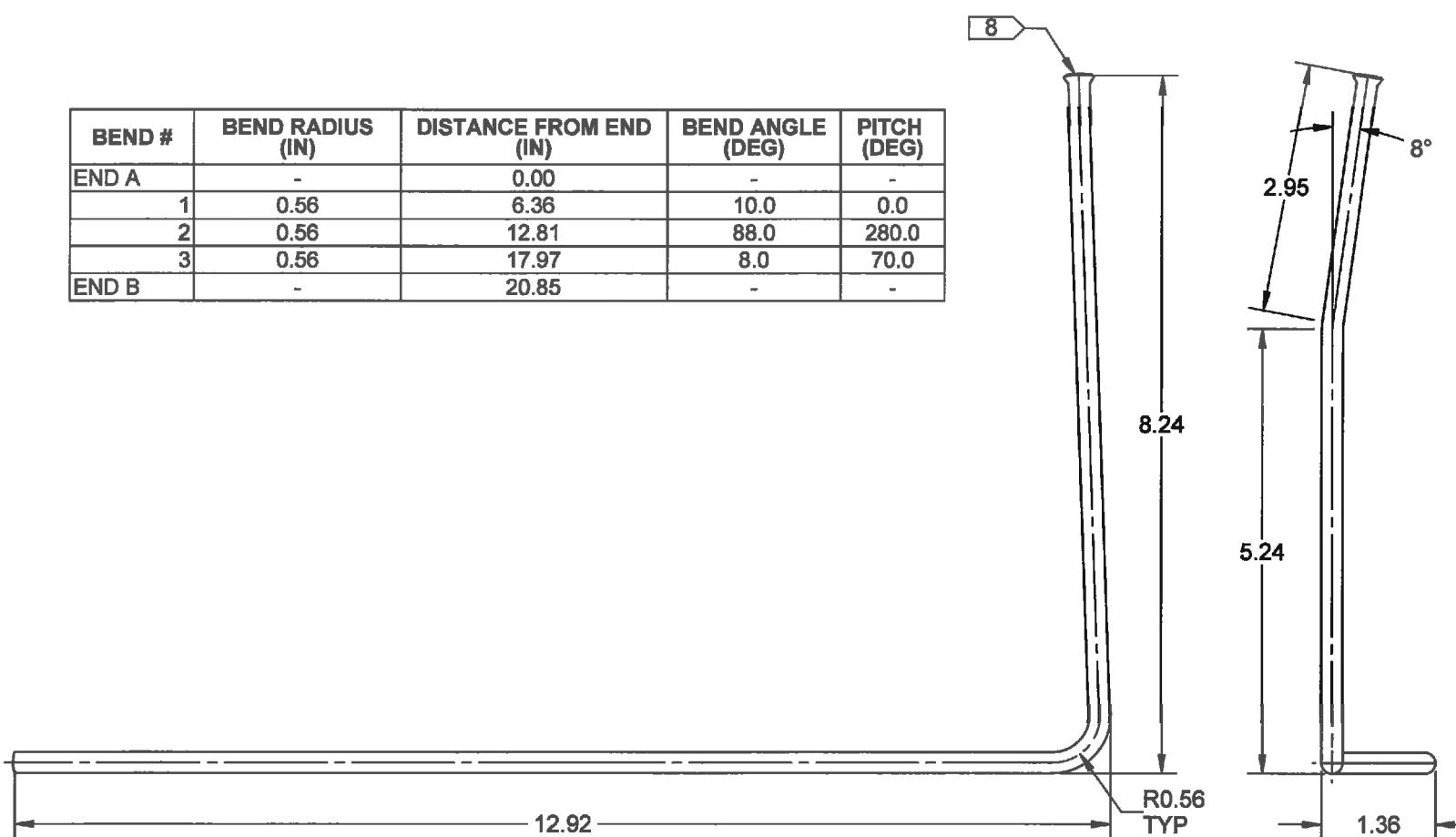
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E4627-051 DRAIN TUBE ASSEMBLY

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	0.56	6.36	10.0	0.0
2	0.56	12.81	88.0	280.0
3	0.56	17.97	8.0	70.0
END B	-	20.85	-	-



NOTES:

- 1) MATERIAL: 6061-T4 ALUMINUM TUBING, $\phi 0.250 \times 0.035$ WALL PER MIL-T-7081
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs
- 8) FLARE TUBE PER MS33584
- 9) MARK LINE WITH BRADY B-999 "FUEL" AND "DRAIN" TAPE

DESIGN	<i>AS</i>	EAGLE COPTERS LTD	
DRAWN	<i>AS</i>	CALGARY, ALBERTA, CANADA	
CHECKED	<i>PF</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	E4627	SHEET 7 OF 19
APPROVED	<i>#</i>	TITLE	SCALE
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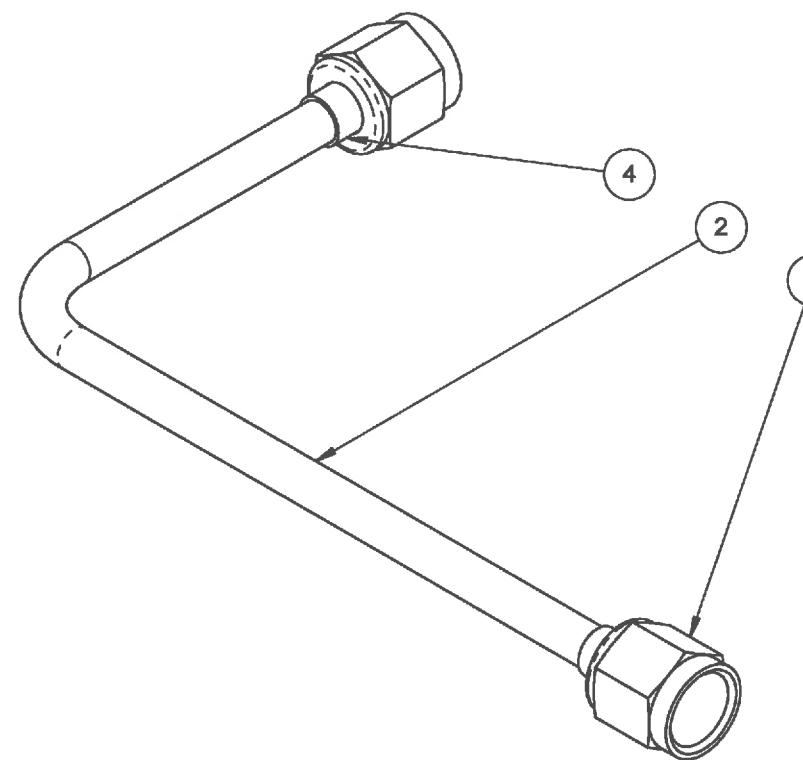
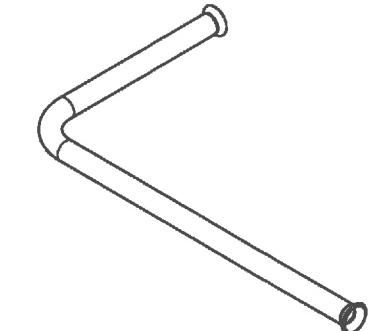
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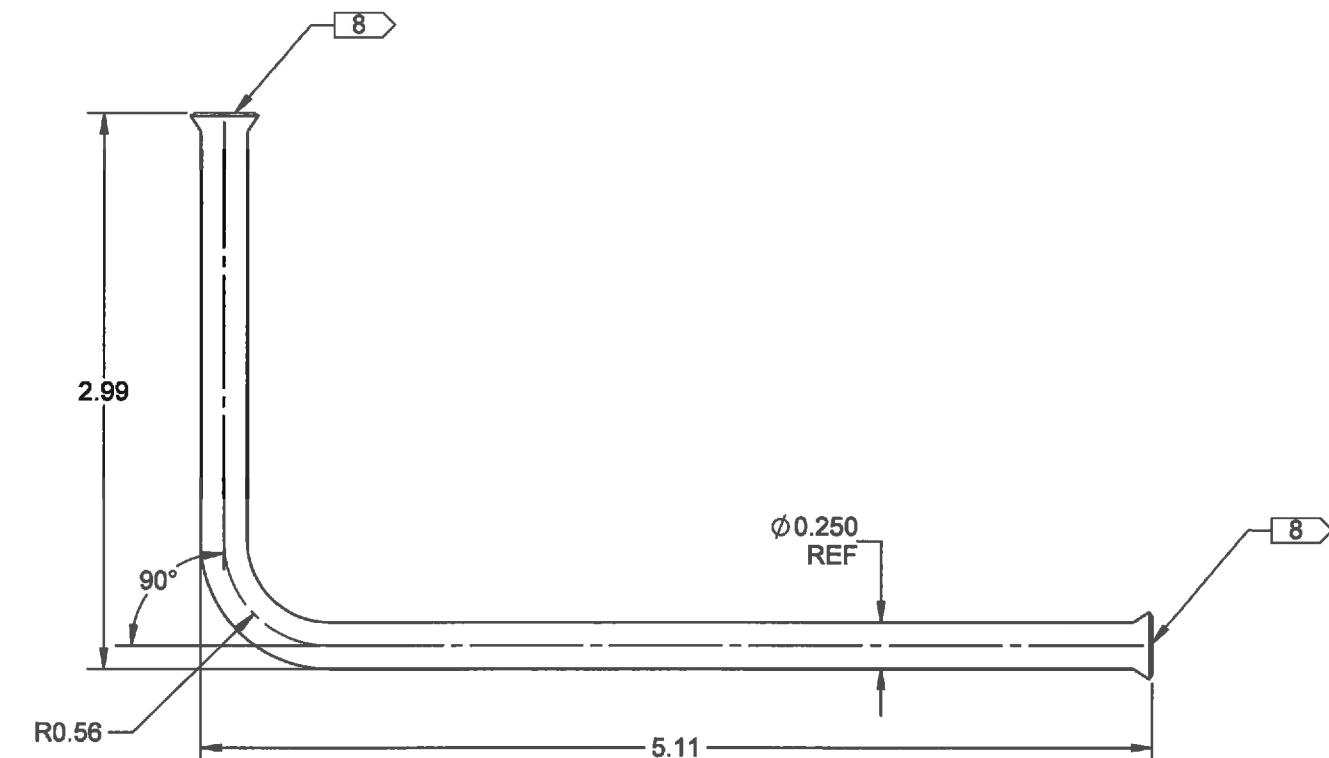
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ITEM NO.	QTY. -053	PART NUMBER	DESCRIPTION
1	X	E4627-053	DRAIN TUBE ASSEMBLY
2	1	E4627-9	TUBE
3	2	AN818-4D	NUT COUPLING
4	2	MS20819-4D	SLEEVE COUPLING

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	0.56	4.48	90.0	0.0
END B	-	7.70	-	-



E4627-053 DRAIN TUBE ASSEMBLY



E4627-9 TUBE

NOTES:

- 1) MATERIAL: 6061-T4 ALUMINUM TUBING, $\varnothing 0.250 \times 0.035$ WALL PER MIL-T-7081
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs
- 8) FLARE TUBE PER MS33584
- 9) PRESSURE TEST TO 100 PSI
- 10) MARK LINE WITH BRADY B-999 "FUEL" AND "DRAIN" TAPE

DESIGN	<i>[Signature]</i>	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA
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APPROVED	<i>[Signature]</i>	
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REV. A		

SHEET 8 OF 19

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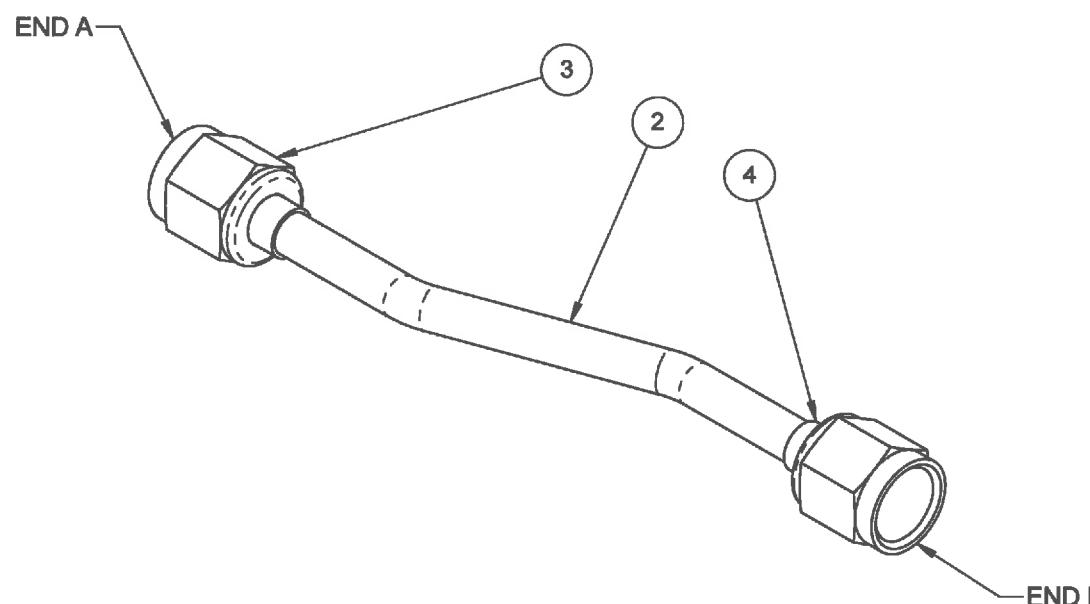
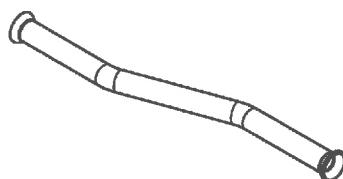
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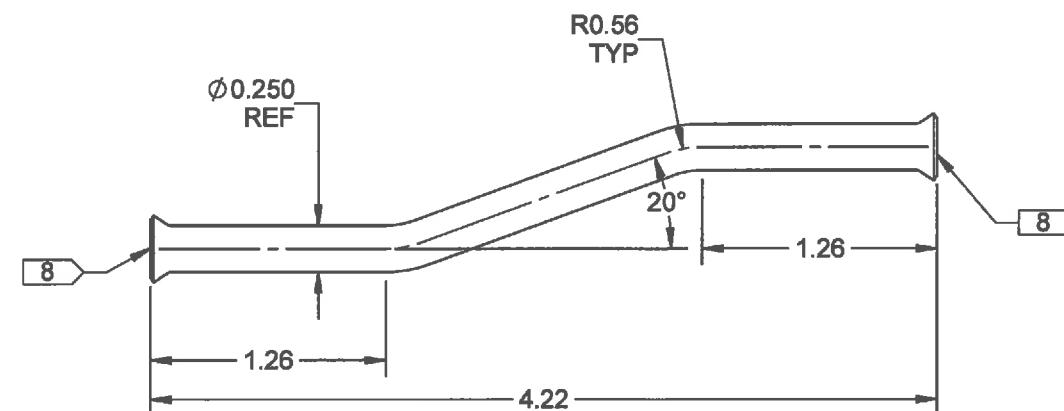
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ITEM NO.	QTY. -055	PART NUMBER	DESCRIPTION
1	X	E4627-055	DRAIN TUBE ASSEMBLY
2	1	E4627-11	TUBE
3	2	AN818-4D	NUT COUPLING
4	2	MS20819-4D	SLEEVE COUPLING

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	0.56	1.32	20.0	0.0
2	0.56	2.79	20.0	180.0
END B	-	4.30	-	-



E4627-055 DRAIN TUBE ASSEMBLY



E4627-11 TUBE

NOTES:

- 1) MATERIAL: 6061-T4 ALUMINUM TUBING, $\phi 0.250 \times 0.035$ WALL PER MIL-T-7081
- 2) FINISH: CHEMICAL CONVERSION COAT PER DAT QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs
- 8) FLARE TUBE PER MS33584
- 9) PRESSURE TEST TO 100 PSI
- 10) MARK LINE WITH BRADY B-999 "FUEL" AND "DRAIN" TAPE

DESIGN	<i>[Signature]</i>	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA
DRAWN	<i>[Signature]</i>	
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APPROVED	<i>[Signature]</i>	
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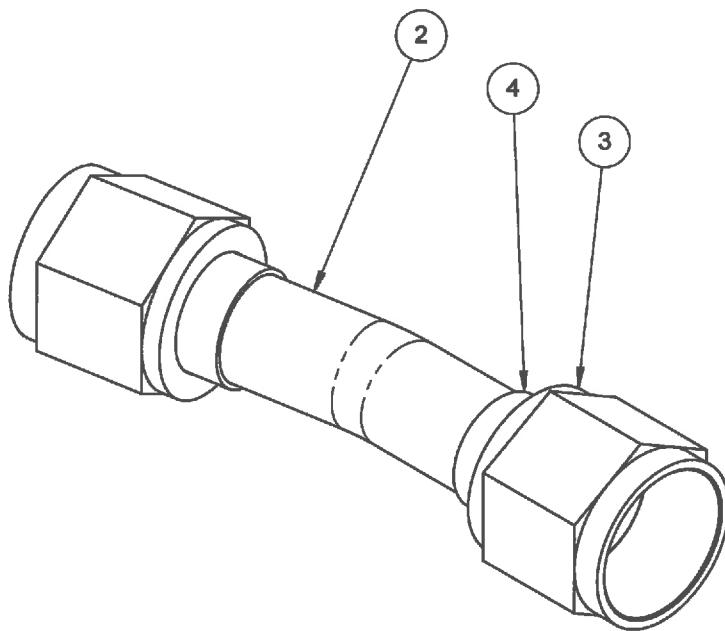
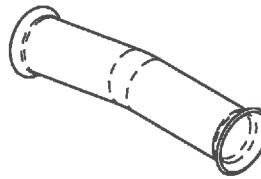
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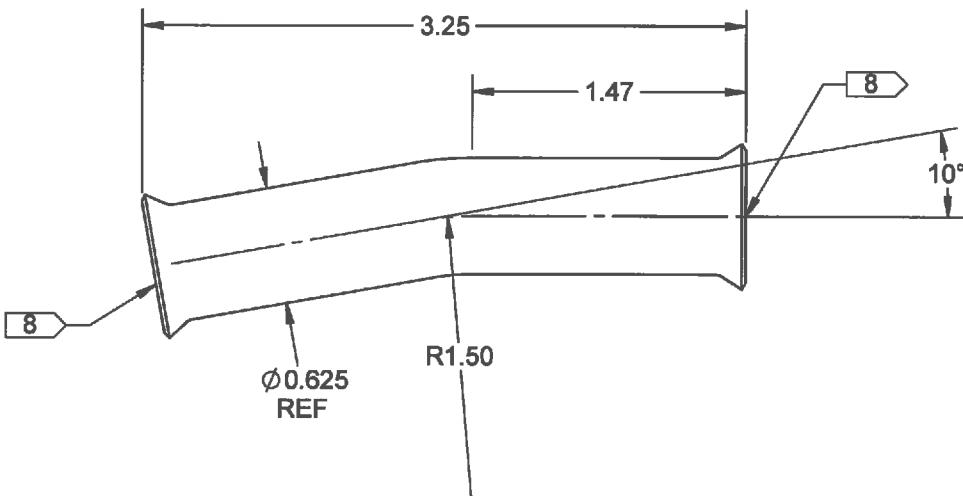
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ITEM NO.	QTY. -059	PART NUMBER	DESCRIPTION
1	X	E4627-059	OIL TUBE ASSEMBLY
2	1	E4627-15	TUBE
3	2	AN818-10D	NUT COUPLING
4	2	MS20819-10D	SLEEVE COUPLING

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
END B	-	3.26	-	-



E4627-059 OIL TUBE ASSEMBLY



E4627-15 TUBE

NOTES:

- 1) MATERIAL: 6061-T4 ALUMINUM TUBING, Ø0.625 X 0.049 WALL PER MIL-T-7081
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs
- 8) FLARE TUBE PER MS33584
- 9) PRESSURE TEST TO 1000 PSI
- 10) MARK LINE WITH BRADY B-999 "ENGINE OIL" TAPE

DESIGN	<i>[Signature]</i>	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA
DRAWN	<i>[Signature]</i>	
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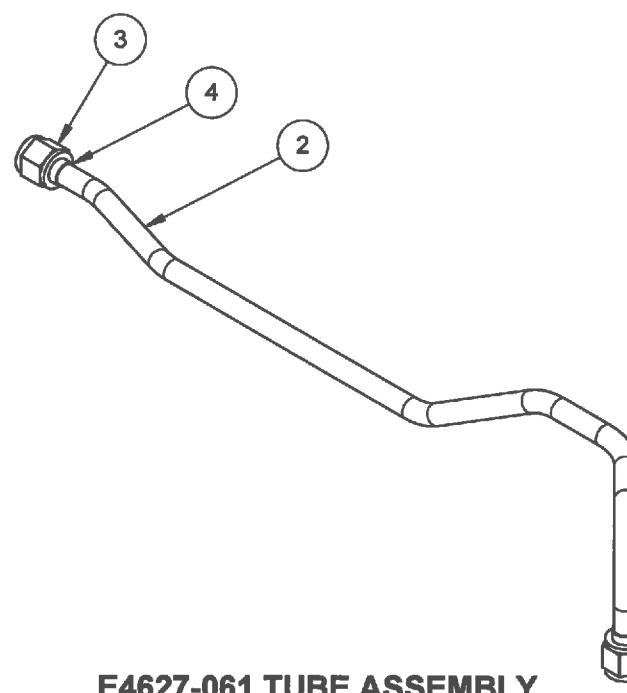
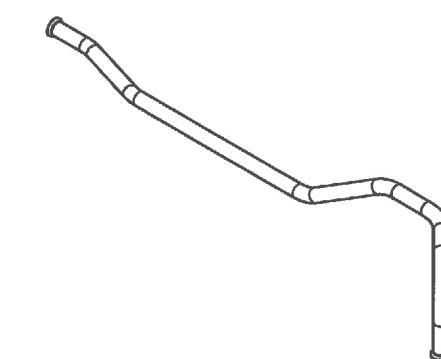
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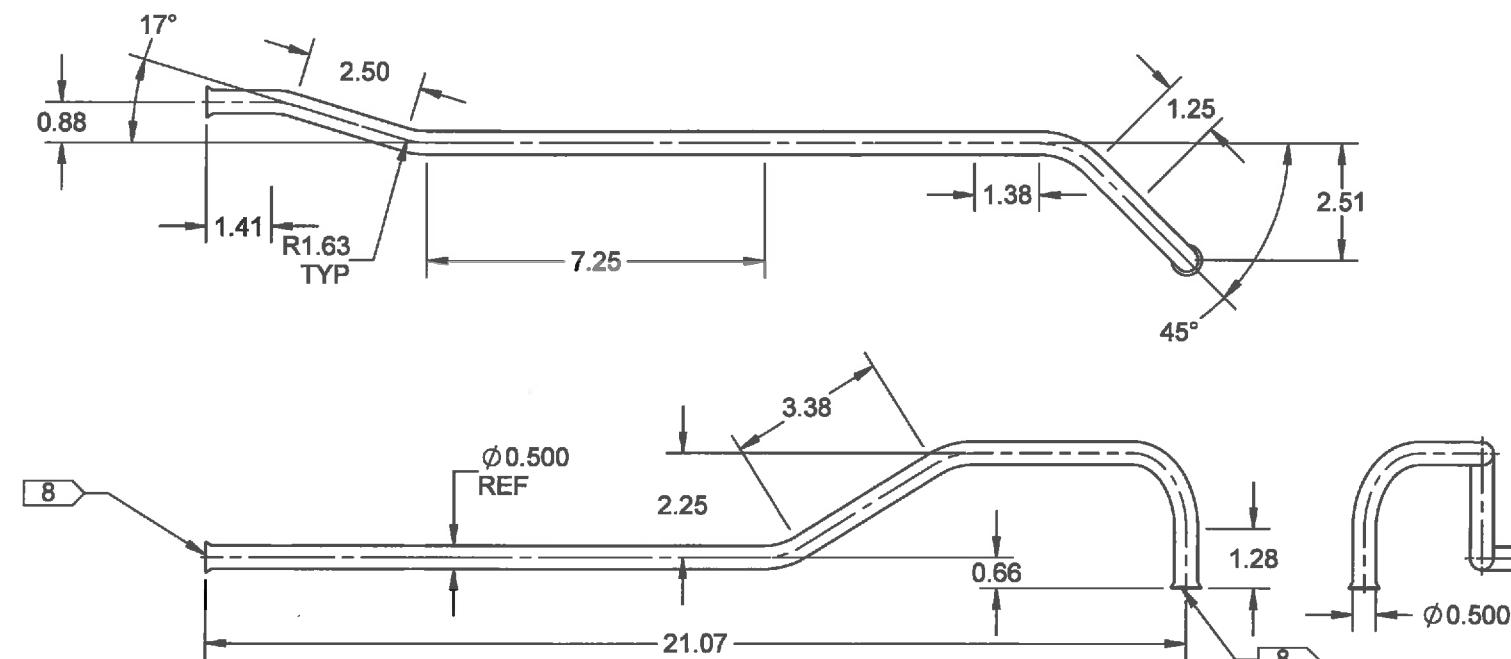
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ITEM NO.	QTY. -061	PART NUMBER	DESCRIPTION
1	X	E4627-061	TUBE ASSEMBLY
2	1	E4627-17	TUBE
3	2	AN818-8D	NUT COUPLING
4	2	MS20819-8D	SLEEVE COUPLING

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	1.50	1.37	83.0	0.0
2	1.50	5.24	46.0	276.0
3	1.50	7.70	33.0	353.0
4	1.50	12.21	29.0	180.0
5	1.50	20.72	16.0	98.0
6	1.50	23.56	15.0	282.0
END B	-	25.55	-	-



E4627-061 TUBE ASSEMBLY



E4627-17 TUBE

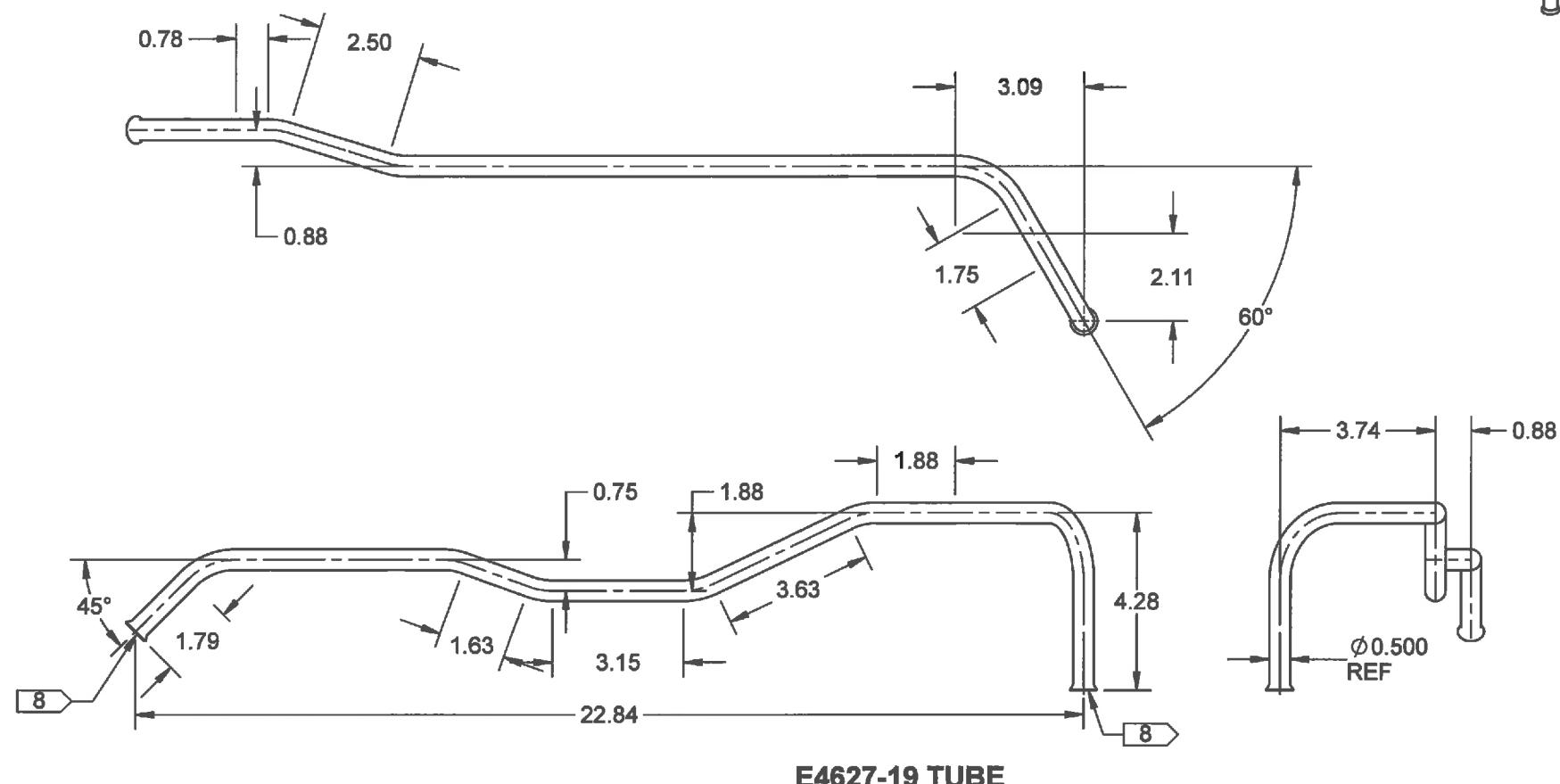
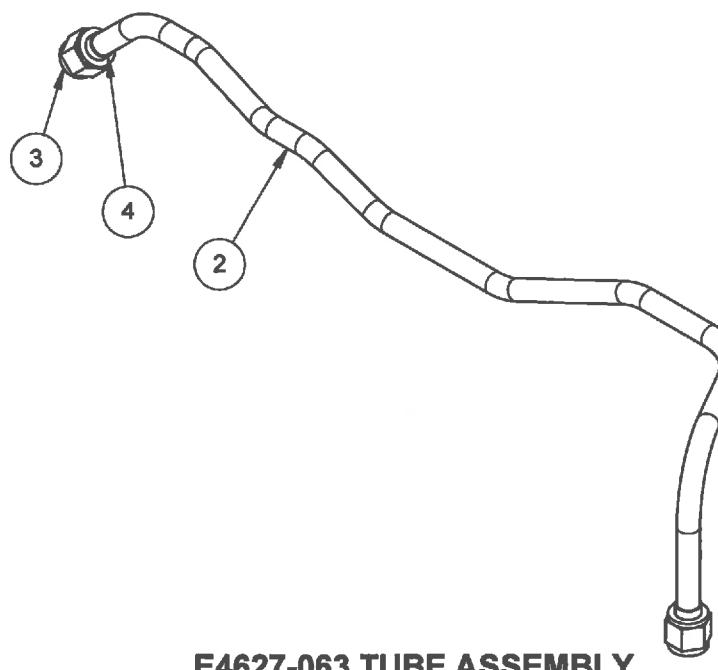
NOTES:

- 1) MATERIAL: 6061-T4 ALUMINUM TUBING, Ø0.500 X 0.049 WALL PER MIL-T-7081
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs
- 8) FLARE TUBE PER MS33584
- 9) PRESSURE TEST TO 225 PSI
- 10) MARK LINE WITH BRADY B-999 "LUBRICATION" TAPE

DESIGN	<i>[Signature]</i>	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA
DRAWN	<i>[Signature]</i>	
CHECKED	<i>[Signature]</i>	
MFG. APPR.	N/A	
APPROVED	<i>[Signature]</i>	
DE APPR.	<i>[Signature]</i>	
DATE	12.12.03	
DRAWING NO.	E4627	
REV. A	SHEET 11 OF 19	
TITLE	LINES	
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ITEM NO.	QTY. -063	PART NUMBER	DESCRIPTION
1	X	E4627-063	TUBE ASSEMBLY
2	1	E4627-19	TUBE
3	2	AN818-8D	NUT COUPLING
4	2	MS20819-8D	SLEEVE COUPLING

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	1.50	1.68	42.0	0.0
2	1.50	4.28	15.0	94.0
3	1.50	6.47	14.0	281.0
4	1.50	8.14	16.0	347.0
5	1.50	10.26	21.0	180.0
6	1.50	14.53	26.0	180.0
7	1.50	18.99	31.0	0.0
8	1.50	21.55	63.0	90.0
9	1.50	25.70	86.0	0.0
END B	-	30.75	-	-

**NOTES:**

- 1) MATERIAL: 6061-T4 ALUMINUM TUBING, $\phi 0.500 \times 0.049$ WALL PER MIL-T-7081
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.08 lbs
- 8) FLARE TUBE PER MS33584
- 9) PRESSURE TEST TO 225 PSI
- 10) MARK LINE WITH BRADY B-999 "LUBRICATION" TAPE

DESIGN	<i>[Signature]</i>	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA
DRAWN	<i>[Signature]</i>	
CHECKED	<i>[Signature]</i>	
MFG. APPR.	N/A	
APPROVED	<i>[Signature]</i>	
DE APPR.	<i>[Signature]</i>	
DATE	12.12.03	
DRAWING NO. E4627		
REV. A		

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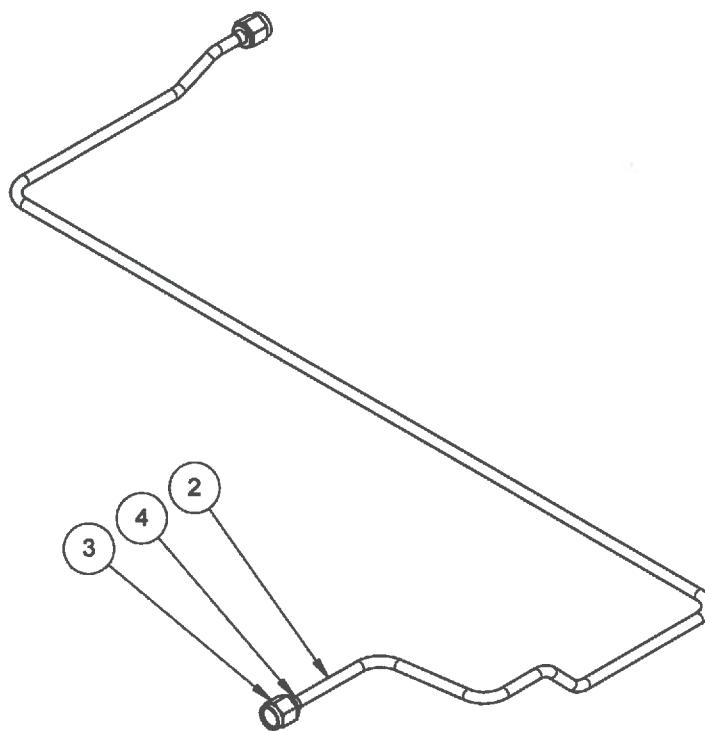
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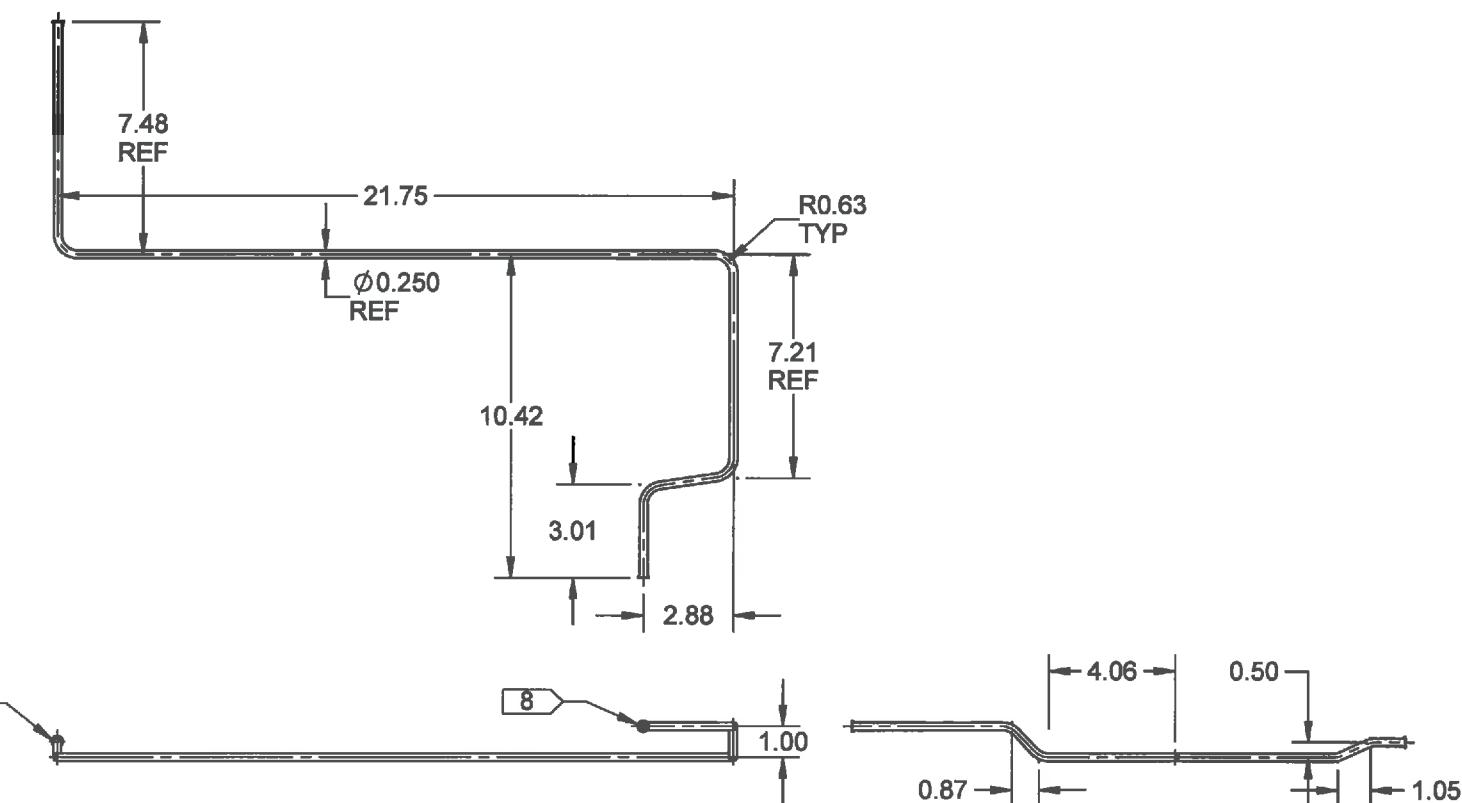
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ITEM NO.	QTY. -065	PART NUMBER	DESCRIPTION
1	X	E4627-065	BRAKE LINE ASSEMBLY
2	1	E4627-21	TUBE
3	2	AN818-4D	NUT COUPLING
4	2	MS20819-4D	SLEEVE COUPLING

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	0.56	1.68	73.0	0.0
2	0.56	4.50	69.0	180.0
3	0.56	6.47	42.0	270.0
4	0.56	8.19	37.0	90.0
5	0.56	11.95	88.0	180.0
6	0.56	33.51	88.0	0.0
7	0.56	38.73	21.0	90.0
8	0.56	40.13	21.0	270.0
END B	-	41.34	-	-



E4627-065 BRAKE LINE ASSEMBLY



E4627-21 TUBE

NOTES:

- 1) MATERIAL: 6061-T4 ALUMINUM TUBING, $\phi 0.250 \times 0.035$ WALL PER MIL-T-7081
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.10 lbs
- 8) FLARE TUBE PER MS33584
- 9) PRESSURE TEST TO 1500 PSI
- 10) MARK LINE WITH BRADY B-999 "HYDRAULIC OIL" TAPE

DESIGN	<i>[Signature]</i>	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA
DRAWN	<i>[Signature]</i>	
CHECKED	<i>[Signature]</i>	
MFG. APPR.	N/A	
APPROVED	<i>[Signature]</i>	
DE APPR.	<i>[Signature]</i>	
DATE	12.12.03	
TITLE	LINES	
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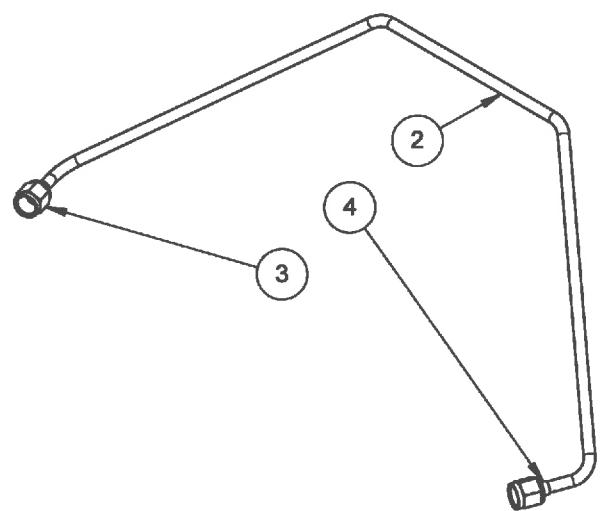
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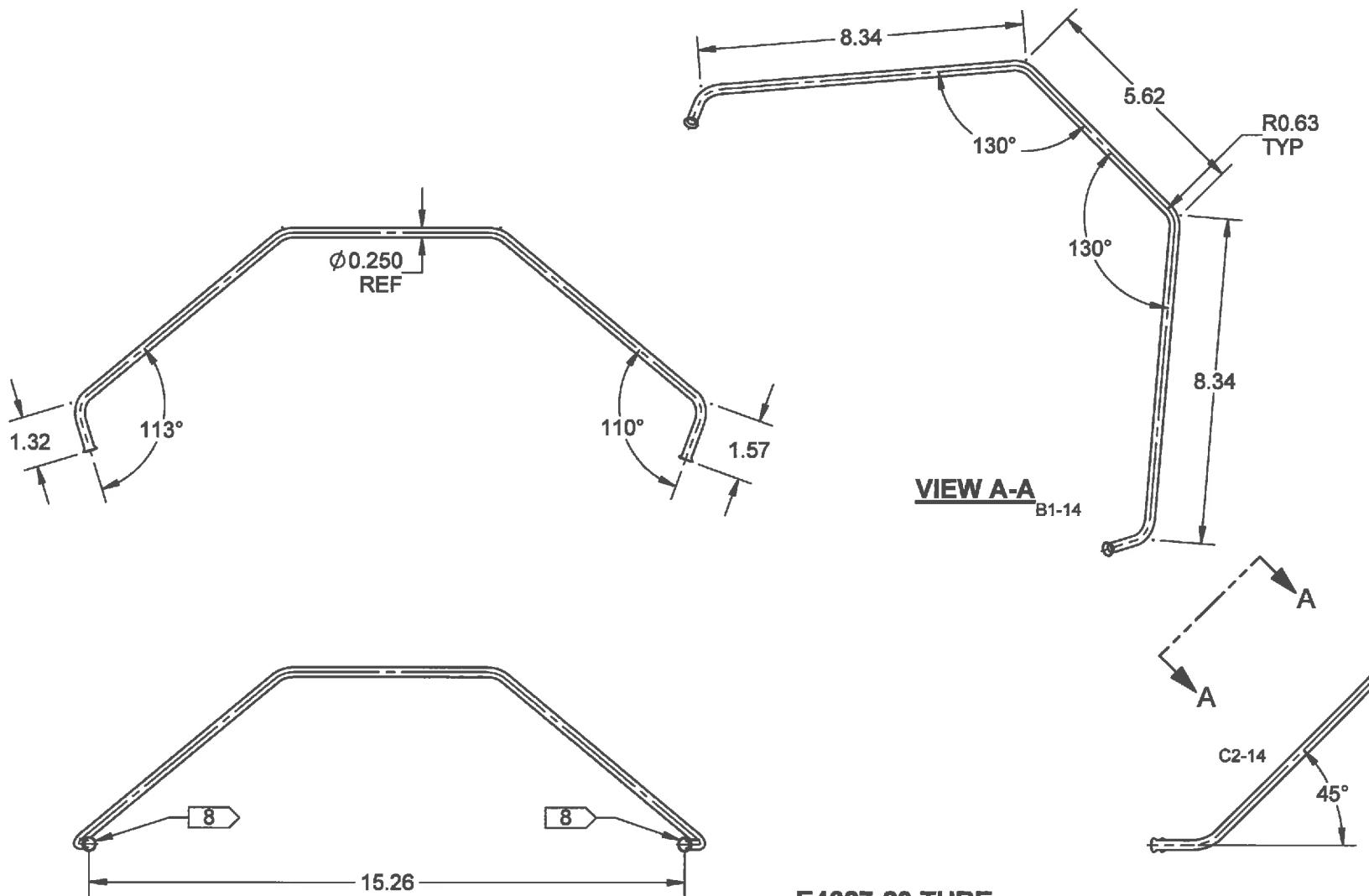
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ITEM NO.	QTY. -067	PART NUMBER	DESCRIPTION
1	X	E4627-067	CROSSOVER LINE ASSEMBLY
2	1	E4627-23	TUBE
3	2	AN818-4D	NUT COUPLING
4	2	MS20819-4D	SLEEVE COUPLING

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	0.56	1.10	70.0	0.0
2	0.56	9.09	52.0	48.0
3	0.56	14.60	49.0	48.0
4	0.56	22.83	71.0	0.0
END B	-	24.43	-	-



E4627-067 CROSSOVER LINE ASSEMBLY



E4627-23 TUBE

NOTES:

- 1) MATERIAL: 6061-T4 ALUMINUM TUBING, $\phi 0.250 \times 0.049$ WALL PER MIL-T-7081
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs
- 8) FLARE TUBE PER MS33584
- 9) PRESSURE TEST TO 1500 PSI
- 10) MARK LINE WITH BRADY B-999 "HYDRAULIC OIL" TAPE

DESIGN	<i>[Signature]</i>	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA
DRAWN	<i>[Signature]</i>	
CHECKED	<i>[Signature]</i>	
MFG. APPR.	N/A	
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DATE	12.12.03	
DRAWING NO.	E4627	
REV. A	SHEET 14 OF 19	
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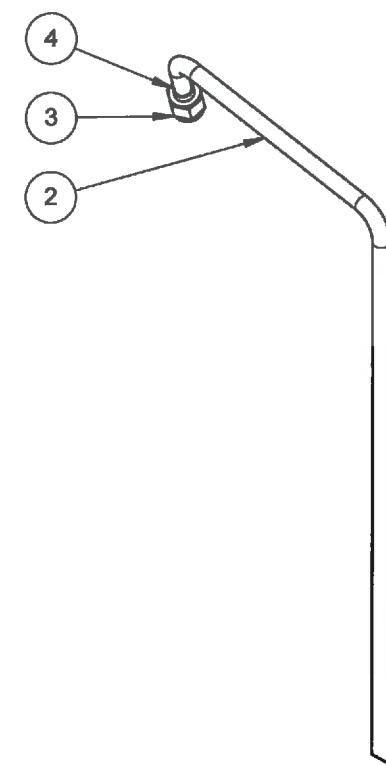
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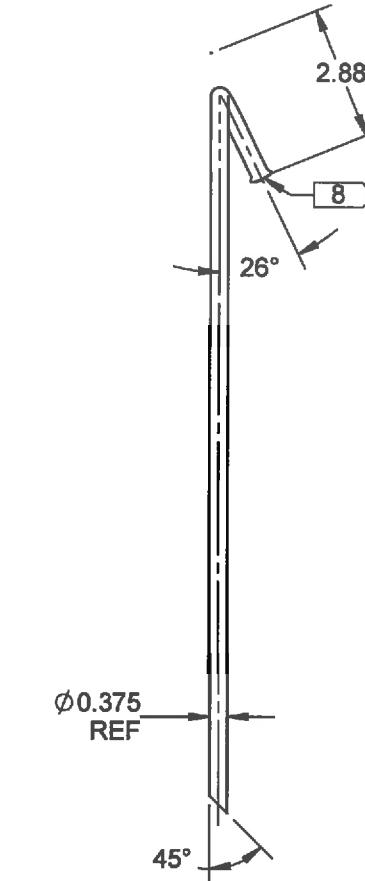
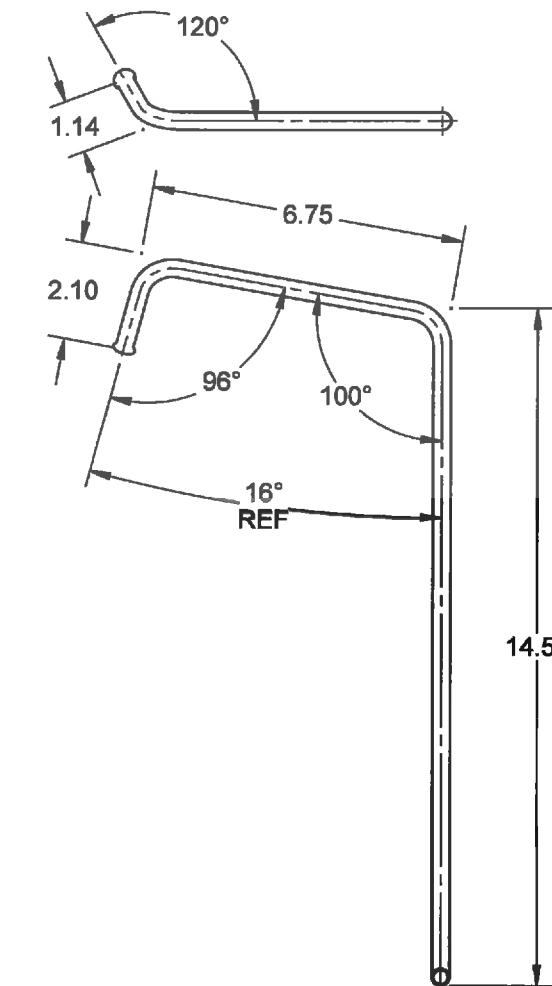
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ITEM NO.	QTY. -069	PART NUMBER	DESCRIPTION
1	X	E4627-069	TX DRAIN LINE ASSEMBLY
2	1	E4627-25	TUBE
3	1	AN818-6D	NUT COUPLING
4	1	MS20819-6D	SLEEVE COUPLING

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	0.94	11.72	74.0	0.0
2	0.94	17.74	90.0	24.0
END B	-	20.20	-	-



E4627-069 TX DRAIN LINE ASSEMBLY



E4627-25 TUBE

NOTES:

- 1) MATERIAL: 6061-T4 ALUMINUM TUBING, $\phi 0.375 \times 0.035$ WALL PER MIL-T-7081
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.09 lbs
- 8) FLARE TUBE PER MS33584
- 9) MARK LINE WITH BRADY B-999 "VENT" TAPE

DESIGN	<i>AS</i>	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWN	<i>AS</i>		
CHECKED	<i>PF</i>	DRAWING NO.	E4627
MFG. APPR.	<i>N/A</i>	REV. A	
APPROVED	<i>#</i>	SHEET 15 OF 19	
DE APPR.	<i>#</i>	TITLE	LINES
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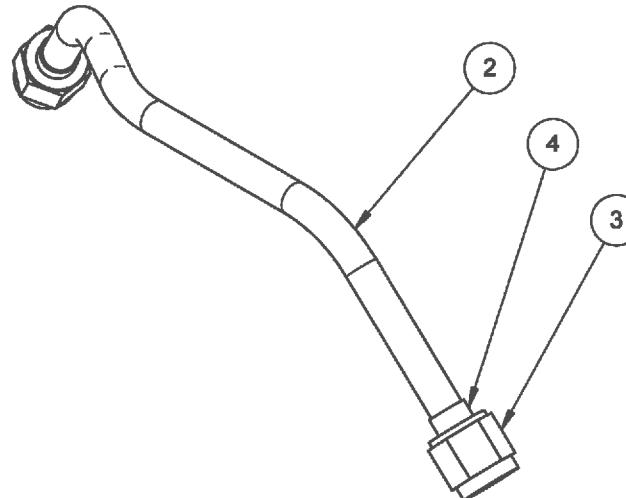
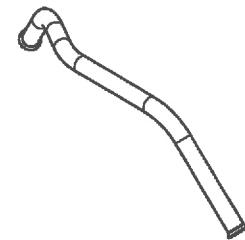
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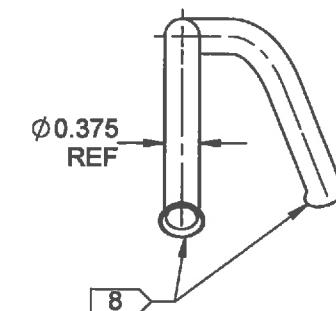
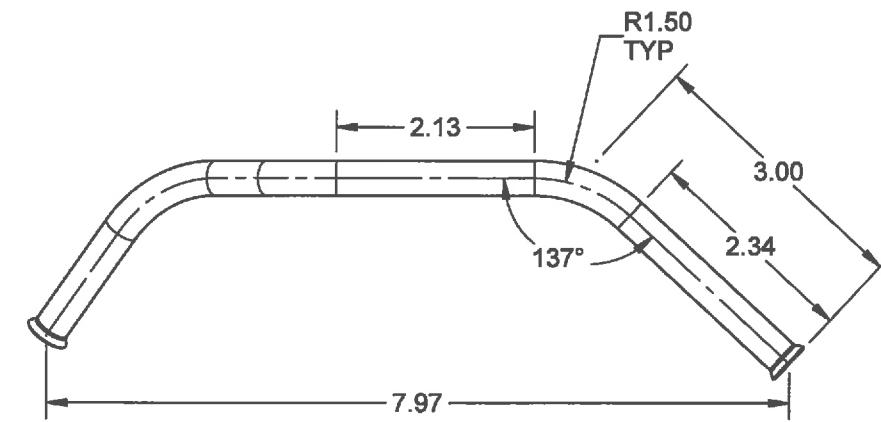
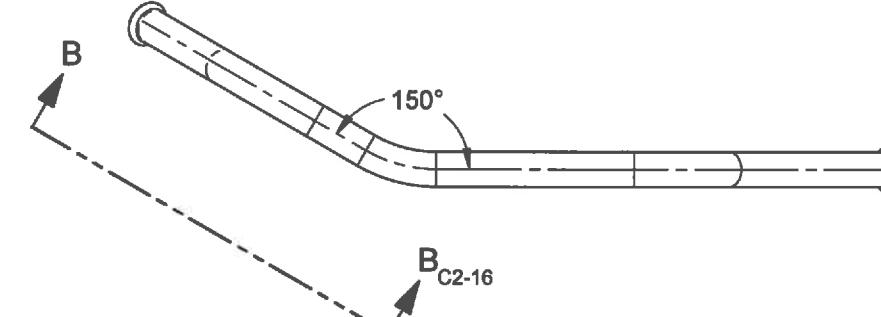
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ITEM NO.	QTY. -071	PART NUMBER	DESCRIPTION
1	X	E4627-071	LINE ASSEMBLY
2	1	E4627-27	TUBE
3	2	AN818-6J	NUT COUPLING (ALT. AN818-6K)
4	2	MS20819-6J	SLEEVE COUPLING (ALT. MS20819-6K)

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	0.94	2.40	43.0	0.0
2	0.94	5.56	30.0	80.0
3	0.94	7.13	46.0	355.0
END B	-	9.79	-	-



E4627-071 LINE ASSEMBLY



E4627-27 TUBE

NOTES:

- 1) MATERIAL: AISI 304A STAINLESS STEEL SEAMLESS ROUND TUBING, $\phi 0.375 \times 0.035$ WALL PER MIL-T-8504
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.13 lbs
- 8) FLARE TUBE PER MS33584
- 9) MARK LINE WITH BRADY B-999 "HYDRAULIC RETURN" TAPE
- 10) MARK LINE WITH BRADY B-999 "FLOW" TAPE FROM END B TO END A
- 11) PRESSURE TEST TO 1500 PSI

DESIGN	<i>[Signature]</i>	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA
DRAWN	<i>[Signature]</i>	
CHECKED	<i>[Signature]</i>	
MFG. APPR.	N/A	
APPROVED	<i>[Signature]</i>	
DE APPR.	<i>[Signature]</i>	
DATE	12.12.03	
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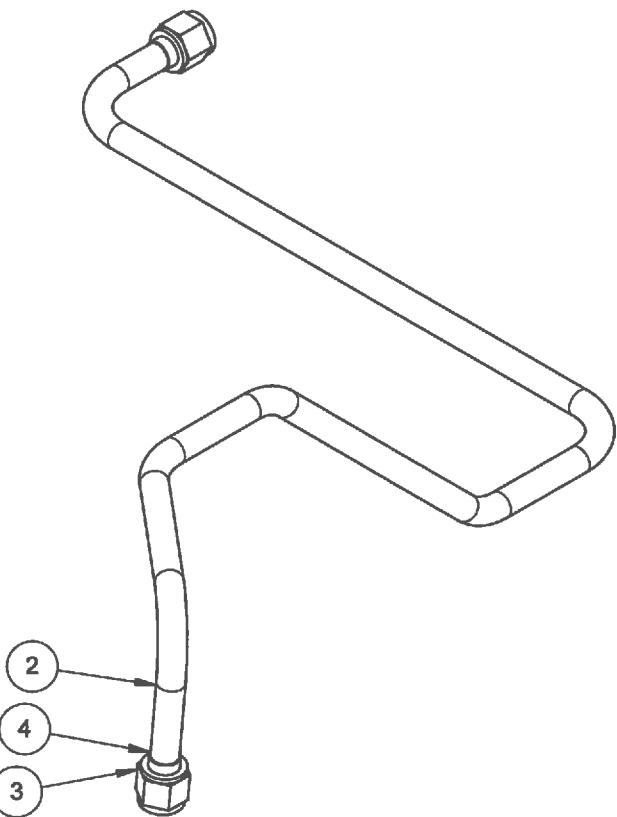
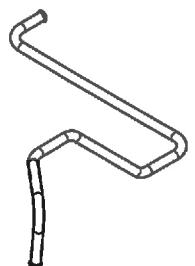
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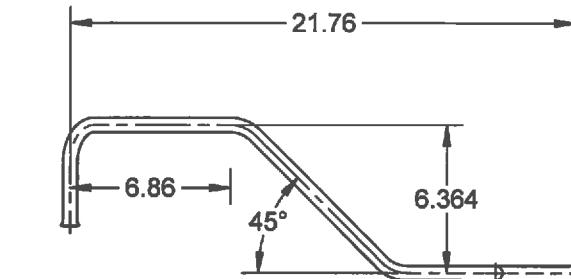
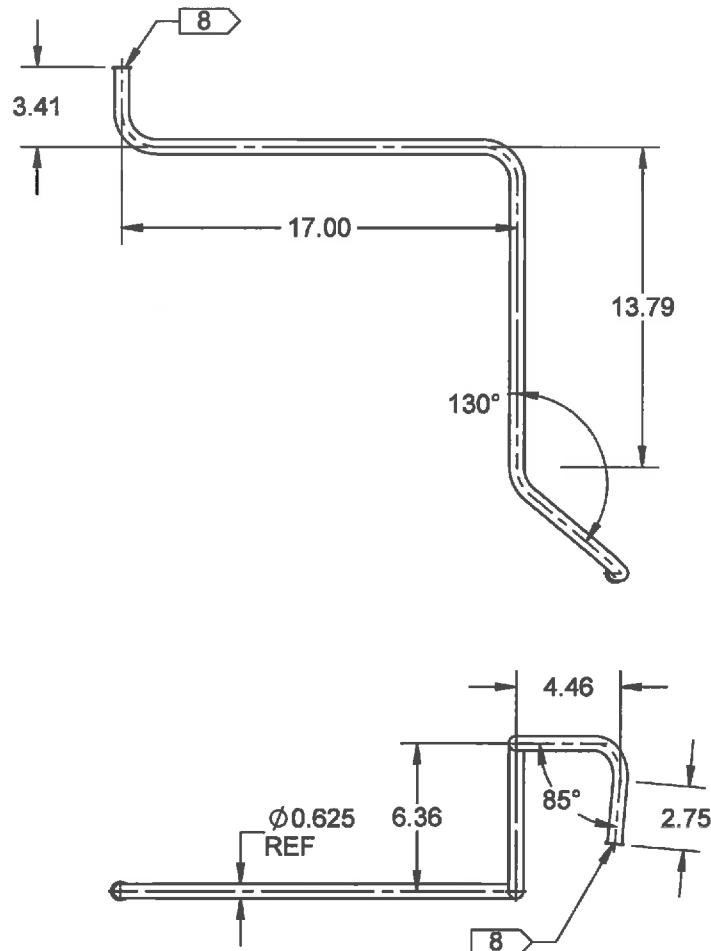
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ITEM NO.	QTY. -073	PART NUMBER	DESCRIPTION
1	X	E4627-073	BLEED AIR LINE ASSEMBLY
2	1	E4627-29	TUBE
3	2	AN818-10J	NUT COUPLING (ALT. AN818-10K)
4	2	MS20819-10J	SLEEVE COUPLING (ALT. MS20819-10K)

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	1.50	2.20	81.0	0.0
2	1.50	18.38	90.0	180.0
3	1.50	23.42	39.0	257.0
4	1.50	32.52	35.0	88.0
5	1.50	36.19	49.0	3.0
6	1.50	42.36	96.0	92.0
END B	-	47.23	-	-



E4627-073 BLEED AIR LINE ASSEMBLY



E4627-29 TUBE

NOTES:

- 1) MATERIAL: AISI 304A STAINLESS STEEL SEAMLESS ROUND TUBING, $\varnothing 0.625 \times 0.035$ WALL PER MIL-T-8504
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.17 lbs
- 8) FLARE TUBE PER MS33584
- 9) PRESSURE TEST TO 270 PSI
- 10) MARK LINE WITH BRADY B-999 "PNEUMATIC" TAPE

DESIGN	<i>[Signature]</i>	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA
DRAWN	<i>[Signature]</i>	
CHECKED	<i>[Signature]</i>	
MFG. APPR.	N/A	
APPROVED	<i>[Signature]</i>	
DE APPR.	<i>[Signature]</i>	
DATE	12.12.03	
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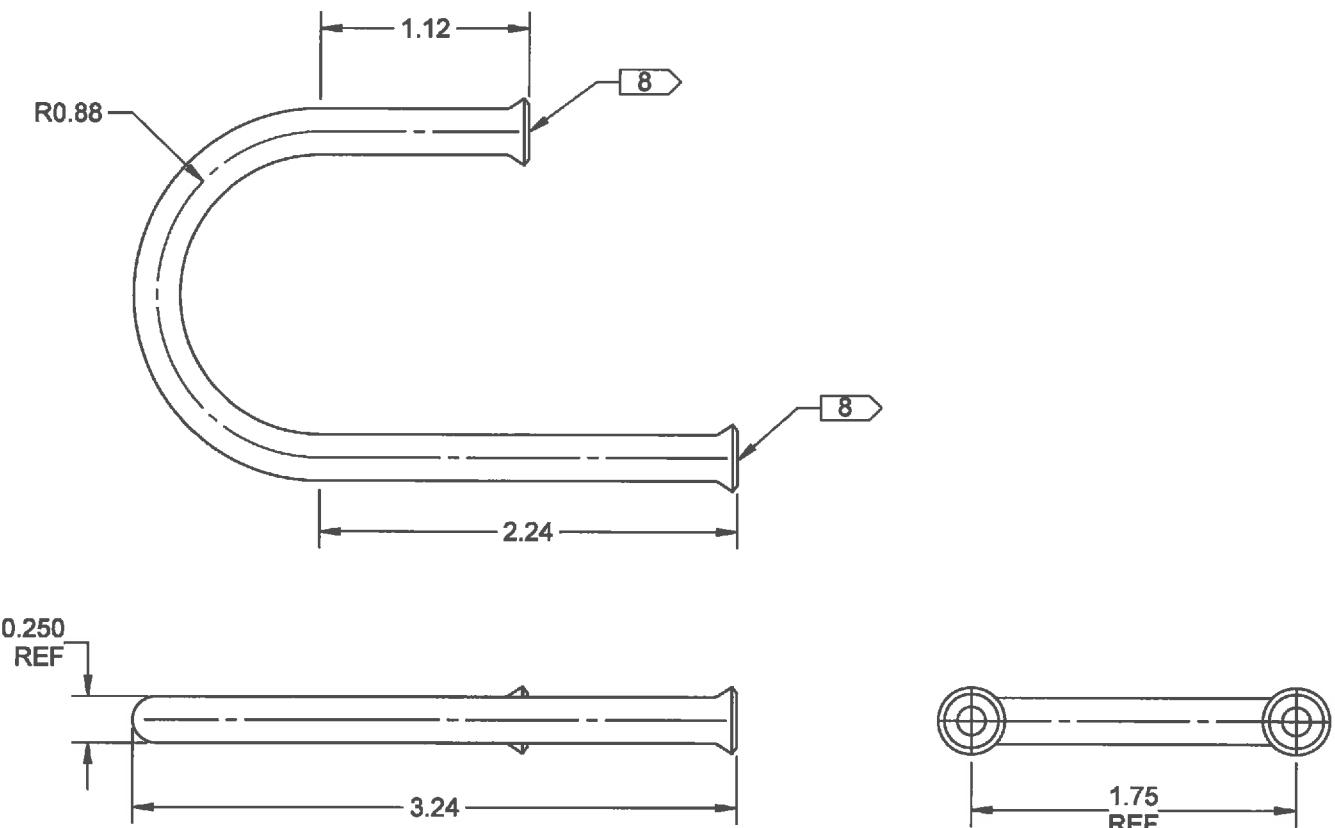
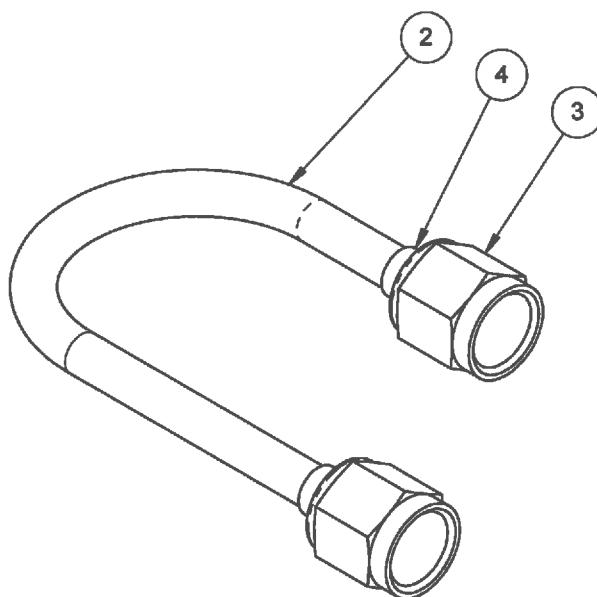
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ITEM NO.	QTY. -075	PART NUMBER	DESCRIPTION
1	X	E4627-075	BLEED AIR SENSE LINE ASSEMBLY
2	1	E4627-31	TUBE
3	2	AN818-4J	NUT COUPLING (ALT. AN818-4K)
4	2	MS20819-4J	SLEEVE COUPLING (ALT. MS20819-4K)



E4627-075 BLEED AIR SENSE LINE ASSEMBLY

E4627-31 TUBE

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	0.56	2.50	90.0	0.0
2	0.56	4.11	90.0	180.0
END B	-	6.33	-	-

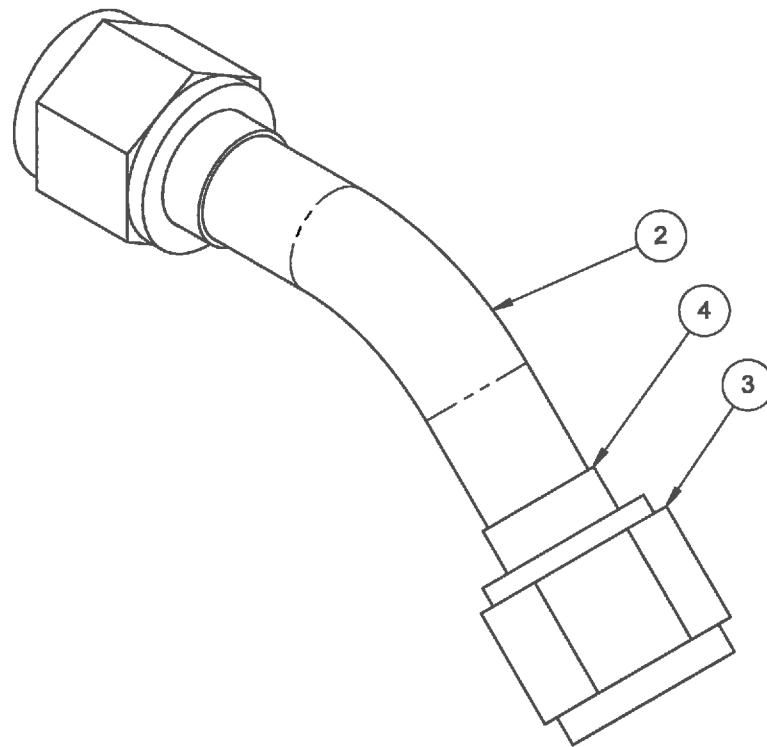
NOTES:

- 1) MATERIAL: AISI 304A STAINLESS STEEL SEAMLESS ROUND TUBING, $\phi 0.250 \times 0.035$ WALL PER MIL-T-8504
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs
- 8) FLARE TUBE PER MS33584
- 9) PRESSURE TEST TO 50 PSI
- 10) MARK LINE WITH BRADY B-999 "PNEUMATIC" TAPE

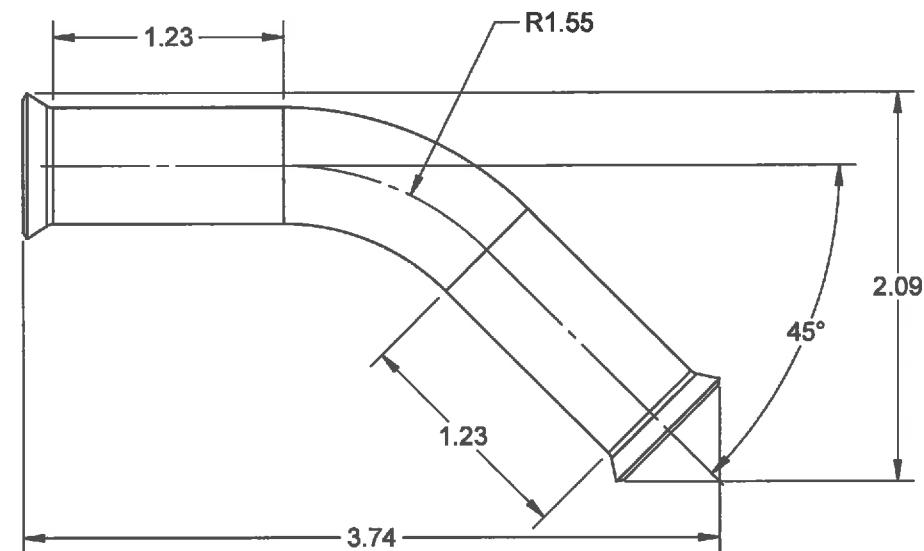
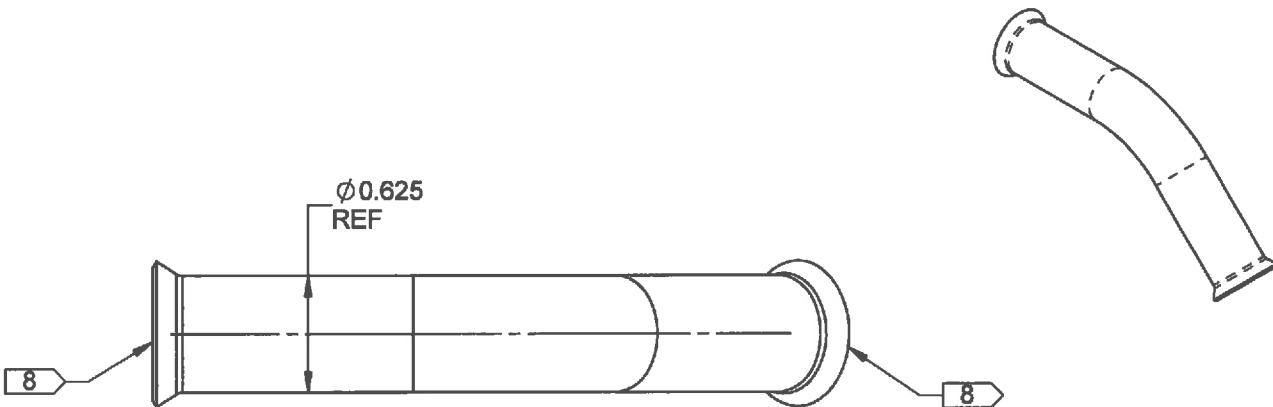
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DRAWN	<i>[Signature]</i>	
CHECKED	<i>[Signature]</i>	
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APPROVED	<i>[Signature]</i>	
DE APPR.	<i>[Signature]</i>	
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DRAWING NO.	E4627	REV. A
SHEET 18 OF 19		
TITLE	LINES	SCALE
NTS		

8 7 6 5 4 3 2 1

ITEM NO.	QTY. -077	PART NUMBER	DESCRIPTION
1	X	E4627-077	BLEED AIR LINE ASSEMBLY
2	1	E4627-33	TUBE
3	2	AN818-10J	NUT COUPLING (ALT. AN818-10K)
4	2	MS20819-10J	SLEEVE COUPLING (ALT. MS20819-10K)



E4627-077 BLEED AIR LINE ASSEMBLY



E4627-33 TUBE

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	1.50	1.57	38.0	0.0
END B	-	3.84	-	-

NOTES:

- 1) MATERIAL: AISI 304A STAINLESS STEEL SEAMLESS ROUND TUBING, Ø 0.625 X 0.035 WALL PER MIL-T-8504
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.13 lbs
- 8) FLARE TUBE PER MS33584
- 9) PRESSURE TEST TO 180 PSI
- 10) MARK LINE WITH BARDY B-999 "PNEUMATIC" TAPE

DESIGN	<i>[Signature]</i>	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA
DRAWN	<i>[Signature]</i>	
CHECKED	<i>[Signature]</i>	DRAWING NO. E4627
MFG. APPR.	<i>[Signature]</i>	
APPROVED	<i>[Signature]</i>	REV. A SHEET 19 OF 19
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